

Work Order ID 139677

December 01, 2015 8:34:19 AM

139677

Page 1

Item ID: D212-725-1-055 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle
 Start Date: 12/1/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/23/2015 Req'd Qty: 1.00 ***1*** Customer:

Reference:

20151201

Approvals: Process Plan: SEA Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4220	A

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-Cut as per dwg 2-Make radius as pre dwg and deburr								

DEC 02 2015

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

DEC 03 2015

120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									

① DP 15-12-3

Work Order ID 139677***139677***

Page 2

Item ID: D212-725-1-055

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 12/1/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00				1			38 9-89 DEC 07 2015
Quality Control									
140	Identify as per dwg & Stock Location: <u>5157</u>	0.00							DEC 07 2015
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									DEC 08 2015
QC	Memo	0.00							
Quality Control									

MCS DEC 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Picklist Print

December 01, 2015 8:35:55 AM

Page 1

Work Order ID: 139677

139677

Parent Item: D212-725-1-055

D212-725-1-055

Parent Item Name: Angle

Start Date: 12/1/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.28 as per dwg revF DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.250X1.0X. 063		Purchased		No			f	14.9000		0.7			

M2024T3A1 250X1 0X 063

2024T3511 ANGLE 1.250" X 1" X .063"W

FF

DEC 02 2015

Location

Loc Qty

Loc Code

MAT051

14.9

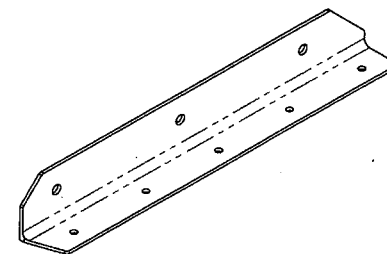
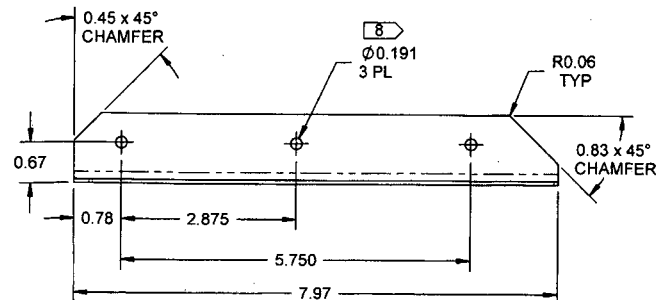
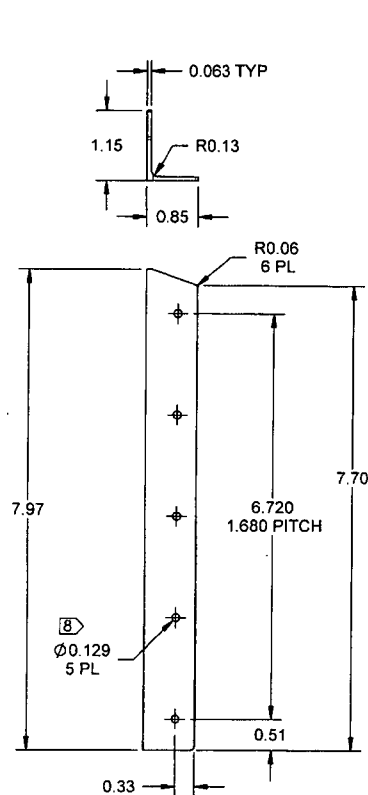
116085

2.9

m133704

12

0.7



RELEASED
2011-08-25

8
D212-725-1-055 ANGLE

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) DIMENSIONS BETWEEN HOLES ARE PROVIDED FOR REFERENCE ONLY.
TRANSFER 0.129, 0.191 HOLES FROM AIRCRAFT

SA 139677

20151201

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4220	REV. A
MFG. APPR.	RF	SHEET 3 OF 4	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SUPPORT BRACKET	NTS
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